

Wednesday, January 18, 2017 7:42:44 AM

155909

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Safe Access Prop Rod

Start Date: 2/1/2017 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 2/3/2017 **Req'd Qty:** 6.00

6

Customer:

Reference: 19-3-2017
31-3-2017

Approvals: _____ **Process Plan:** 9-89 **Date:** IAN 20 2017 **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 155909

Wednesday, January 18, 2017 7:42:44 AM

155909

Page 2

Item ID: D350-1021-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Safe Access Prop Rod

Start Date: 2/1/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/3/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-1021-011 Location: F8019								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

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9-89
MAR 10 2017

DAS
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9-89
MAR 10 2017

DAS
21
9-89
MAR 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, January 17, 2017 2:10:07 PM

Page 1

Work Order ID: 155909

155909

Parent Item: D350-1021-011

D350-1021-011

Parent Item Name: Safe Access Prop Rod

Start Date: 2/1/2017

Required Date: 2/3/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 16.04.20 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5 *AN4-5* BOLT		Purchased	No				Each	20.0000	**	6	DAS 6 9-89	MAR 08 2017	DAS 28 9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST350			20					
					m136444			20					
D5311-041 *D5311-041* Engine Cowl Swivel Prop Rod Assembly		Manufactured	No				Each	1.0000	**	6	DAS 6 9-89	MAR 08 2017	DAS 28 9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST359			1					
					146763			1					
D5418-1 *D5418-1* Placard		Manufactured	No				Each	12.0000	**	12	DAS 6 9-89	MAR 08 2017	DAS 28 9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST168			12					
					155168			12					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Tuesday, January 17, 2017 2:10:07 PM

Page 2

Work Order ID: 155909

155909

Parent Item: D350-1021-011

D350-1021-011

Parent Item Name: Safe Access Prop Rod

Start Date: 2/1/2017

Required Date: 2/3/2017

Start Qty: 6.00

Required Qty: 6.00

AN310-4
Nut
Purchased No

Each 83.0000 6

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DAS
6
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MAR 02 2017

Location	Loc Qty	Loc Code
GA	25	
M127815	25	
OVER007	40	
M135704	0	
M136295	40	6
ST331	18	
M135999	18	

DAS
27
9-89

AN970-4
Washer
Purchased No

Each 110.0000 12

**

DAS
6
9-89

DAS
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9-89

MAR 02 2017

Location	Loc Qty	Loc Code
ST260a	100	
m135390	0	
m136044	50	5
m136406	50	
ST321	10	136787 X7
m135600	10	

DAS
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MS24665-155
Cotter Pin
Purchased No

Each 290.0000 6

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DAS
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MAR 02 2017

Location	Loc Qty	Loc Code
ST289	290	
m129163	290	6

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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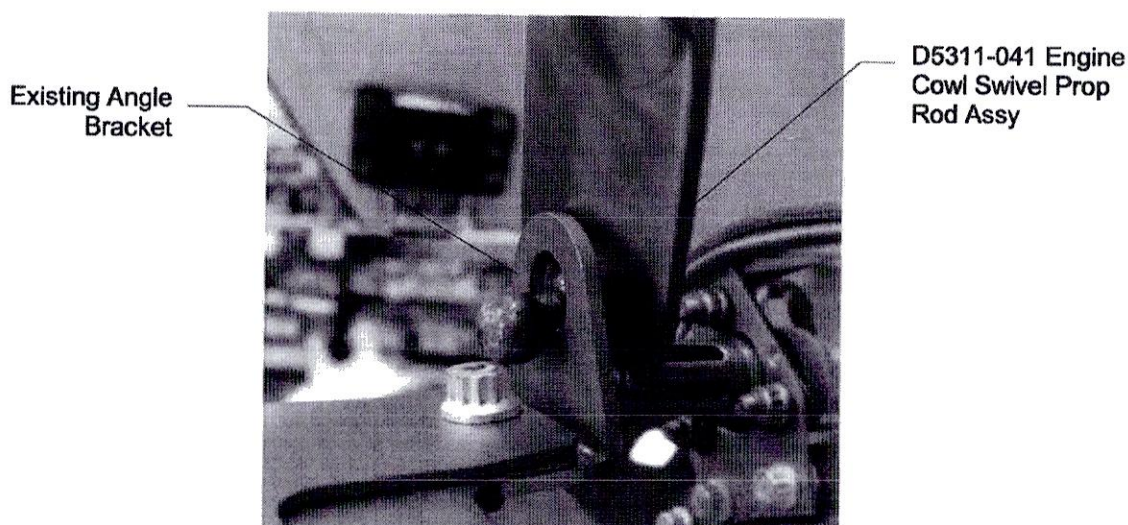


Figure 5: Alternate Prop Rod Mounting Location

4.0 WEIGHT AND BALANCE

The following table shows the net weight increase associated with the D350-1021-011 Engine Cowl Swivel Prop Rod kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-1021-011 Engine Cowl Swivel Prop Rod Kit	0.6 lb 0.3 kg	+12.0 in +0.3 m	+7.2 in-lb +0.1 m-kg	163.4 in 4.2 m	98 in-lb 1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D350-1021-011	ENGINE COWL SWIVEL PROP ROD KIT
1	D5311-041	ENGINE COWL SWIVEL PROP ROD ASSEMBLY
1*	D3622-15	BALL STUD
2	D5418-1	PLACARD
1	AN310-4	NUT, CASTELLATED
1	AN4-5	BOLT
2	AN970-4	WASHER
1	MS24665-155	COTTER PIN
1*	LN9016-06K	WASHER (ALT: LN9016-06L, 23116TK060X)
1*	LN9161-06M	NUT (ALT: ASN52320BH060N)

* PART INCLUDED IN D5311-041 ASSEMBLY